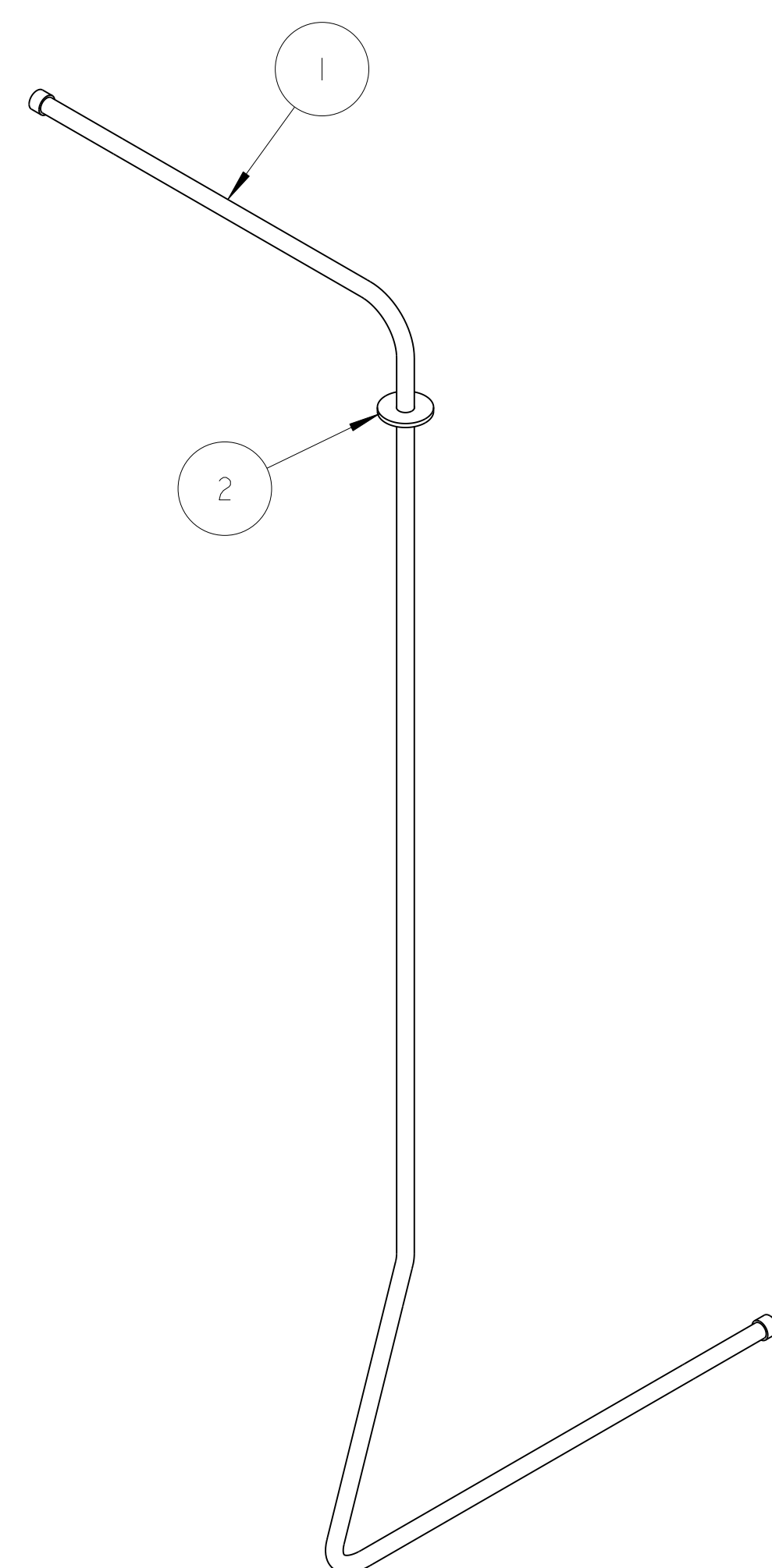
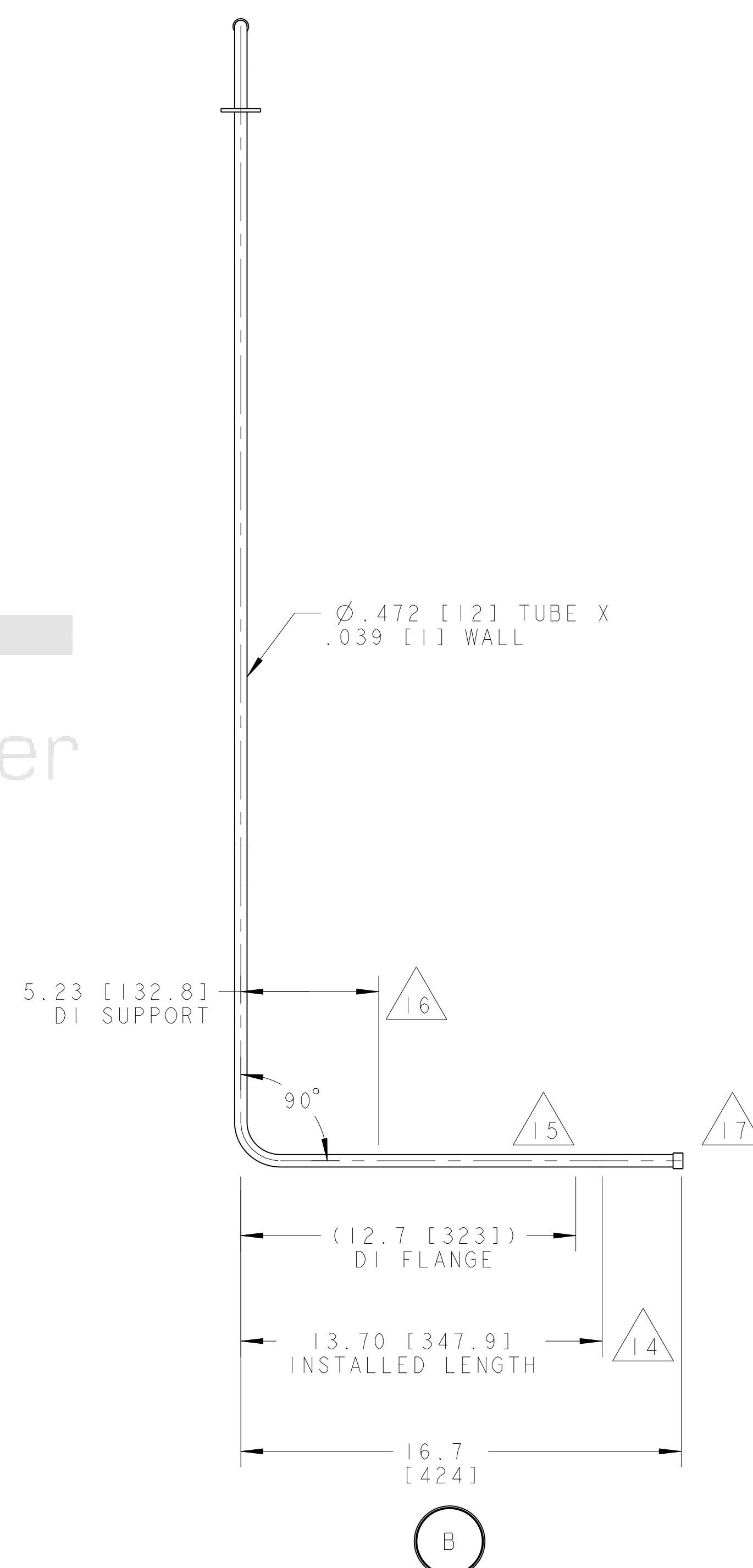
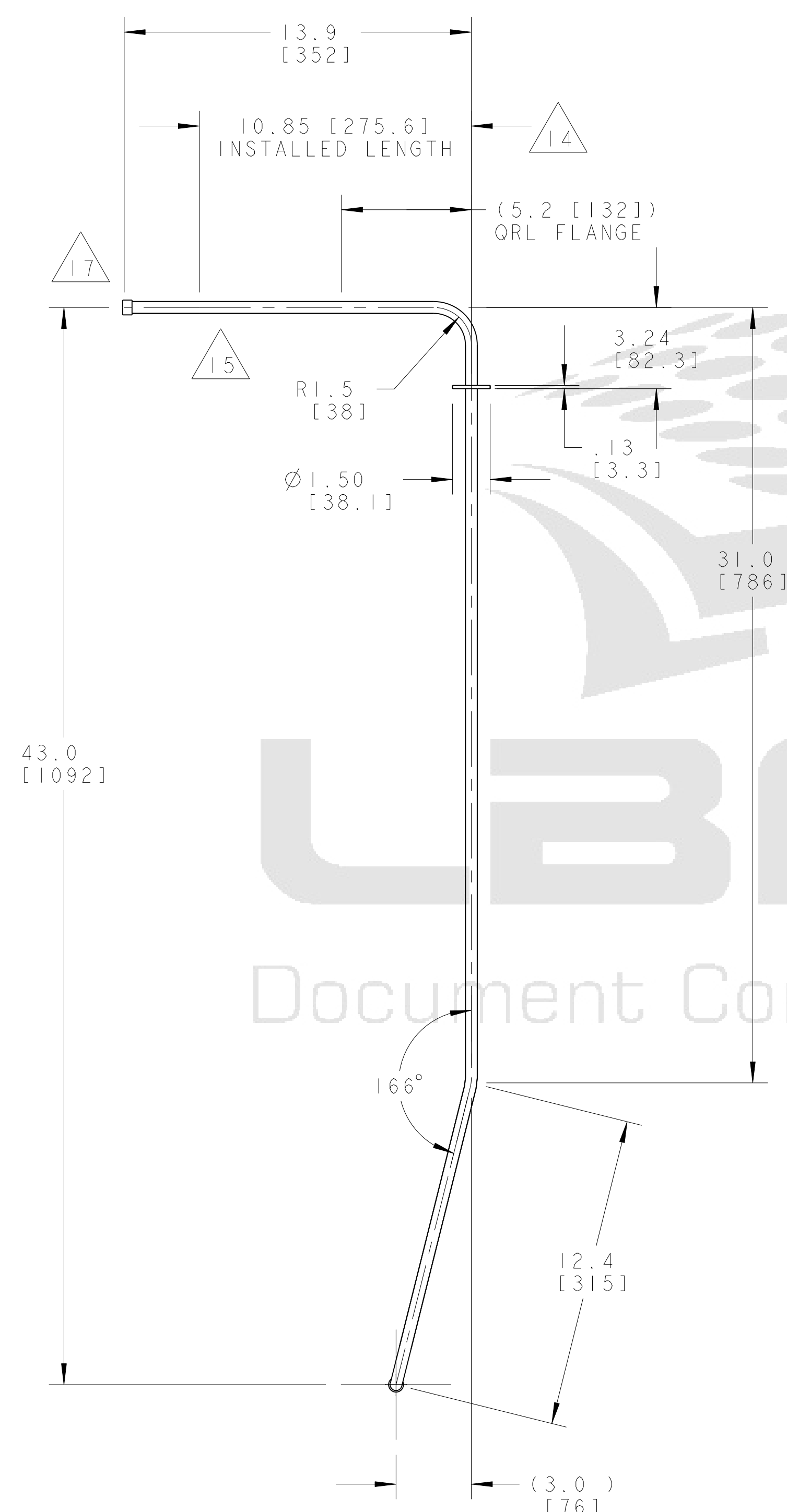
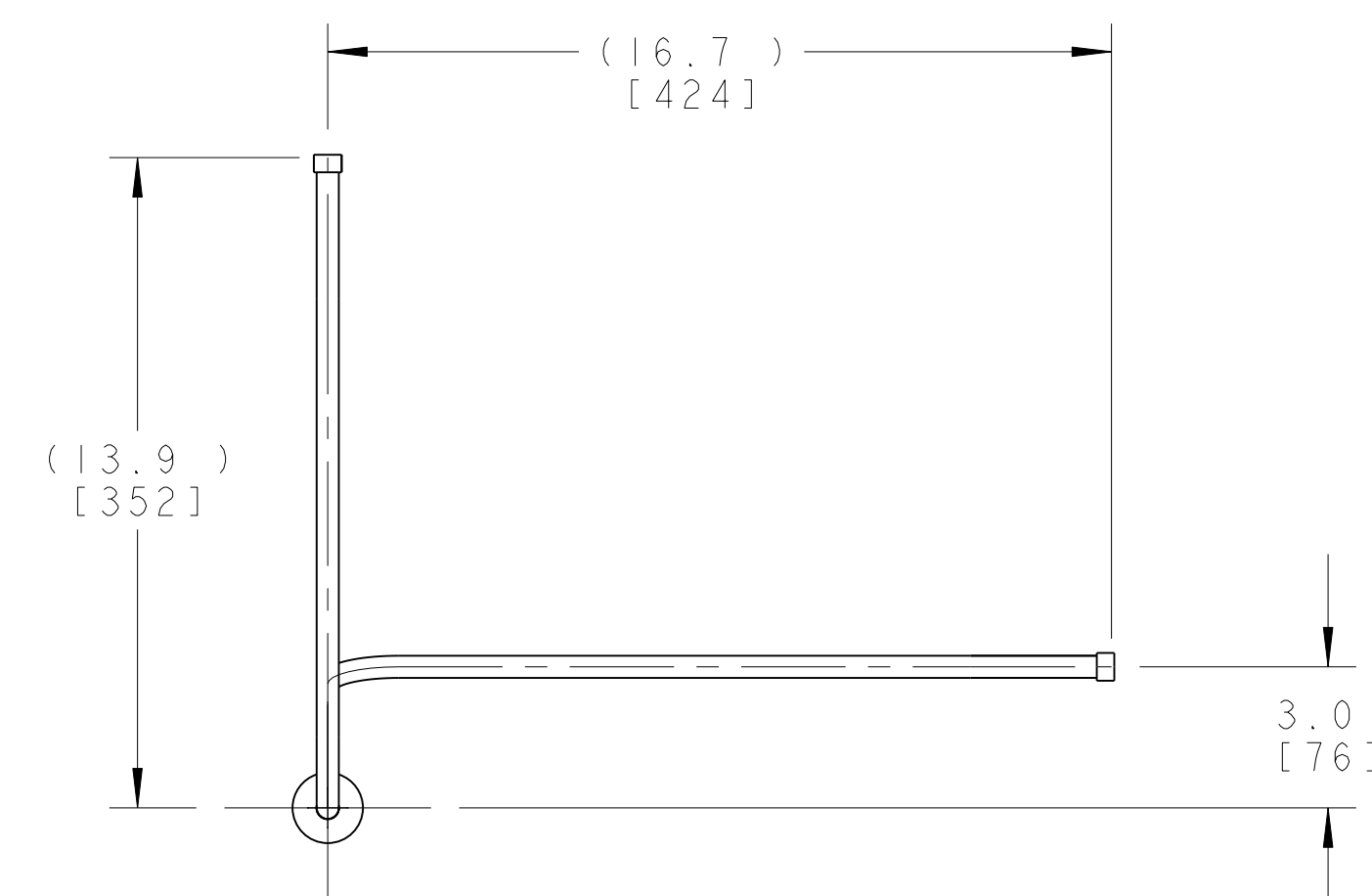
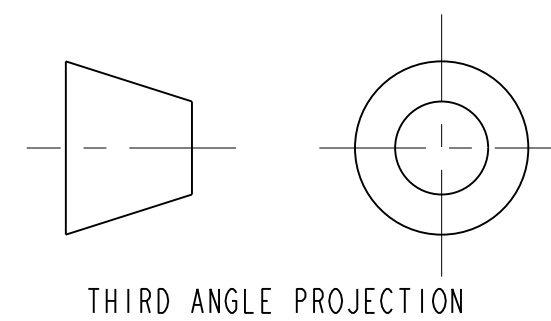


1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN  $\pm .010$ .
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989. B
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF  $\pm 0.063$ ".
15. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
17. CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS. B




SCALE 1/4



C	RLM	JP2	1/16/04	UPDATE TITLE	
B	ARH	SPV	8/1/4/00	REVISED PIPE GEOMETRY, REVISED DRAWING NOTES 13, 16 & 17	
A	ARH	SPV	11-01-02	INITIAL RELEASE	
REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED		
TOLERANCES	X, X ± 0.1	FRACTION ± 1/64
	X.XX ± 0.03	Angles ± 1.0°
	X.XXX ± 0.010	FINISH 125 $\sqrt{Ra}$
DO NOT SCALE PRINT		
THREADS ARE CLASS 2		
CHAMFER ENDS OF ALL SCREW THREADS 30°		
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		
BREAK EDGES .015 MAX. ON MACHINED WORK		
REMOVE BURRS, WELD SPATTER OR LOGGE SCUM		
IN ACCORDANCE WITH ASME Y14.5M & B46.1		

2	-	1	FLANGE, SPIDER INTERFACE			SS 304L
1	-	1	TUBE, PER ASTM A269			SS 304L
ITEM	PART NO.	REQD	DESCRIPTION			MATERIAL
<b>SHOP ORDERS</b>						
ALT. NO.	NO.	REQD	NO.	SER. NO.	DATE	REMARKS
TO	BY	REQD	BY	ISSD		
TO	BY	REQD	BY	ISSD		
<p align="center"> <b>ERNEST ORLANDO LAWRENCE</b>  <b>BERKELEY NATIONAL LABORATORY</b>          UNIVERSITY OF CALIFORNIA - BERKELEY       </p> <div style="text-align: right;">  </div> <p align="center">         LHC IR FEEDBOX          CRYONICS          PIPE, CC3, DFBX B       </p>						
PROJECT NAME	N/A					
PROJECT NUMBER	N/A					
PROJECT DATE	N/A					
PROJECT R/L	L MANTIA	DATE	13-Dec-01			
CNR	Jr Zannakis/S.Virostek	DATE	01-Nov-02			
CHK	Jr Zannakis/D.Osteltz	DATE	08-AUG-02			
MICROFILMED:				DWG. TYPE	SHOWN ON	SCALE: 1/4
				ASSEM	-	
PATENT CLEAR:				DESIGN ACCT:	CATEGORY CODE:	DWS. NO.: SIZE: REV.
				Z5LCLE2	LH2003	2515216